

Date: Monday, 02/03/2009 11:26:06 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ACCESS PANEL
Job Number : 46203	
Estimate Number : 13556	
P.O. Number :	Part Number : D37055
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3705 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 05038	Material :
Written By :	Due Date : 16/03/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 09.03.02</u>	
Comment : Est Rev:A 08-08-20 new issue DD verified by:EC Est Rev:B 09-01-09 rev.c as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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Comment: Qty.: 0.3281 sf(s)/Unit Total : 1.9688 sf(s)
6061-T6 .040 Sheet
batch: 105842 B 9-3-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3705
Dwg Rev: C
Prog Rev: C

B 9-3-982- Deburr if necessary B 9-3-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 9-3-9**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK09.03.09 8

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE-1
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N/A**Comment:** Deburr if necessary.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL

Job Number: 46203

Part Number: D37055

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



N/A



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 09-03-10

(8)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:55

OVEN TEMPERATURE:

320°

FINISH TIME:

11:25

cmp/BR

09/03/10

(X8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-10

(X8)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 181

SS

09/03/11

(X8)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/11

Job Completion



mf 09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

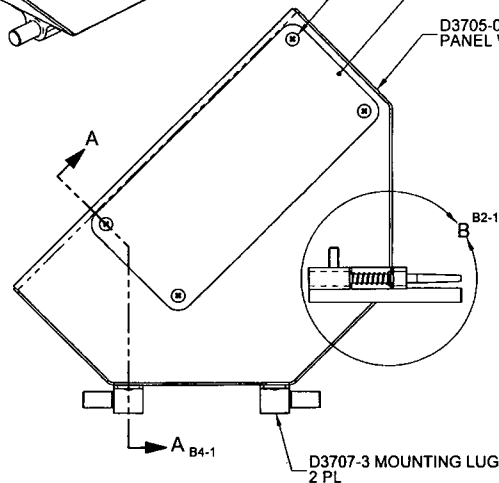
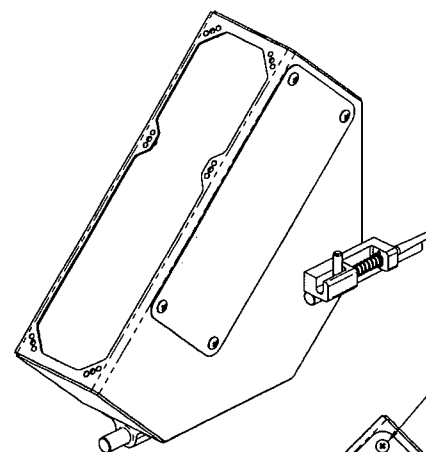
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET



D3705-041 INSTRUMENT PANEL ASS'Y

D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.97 lbs

MS21075L3 NUTPLATE
REF

AN526C1032R6 SCREW
4 PL

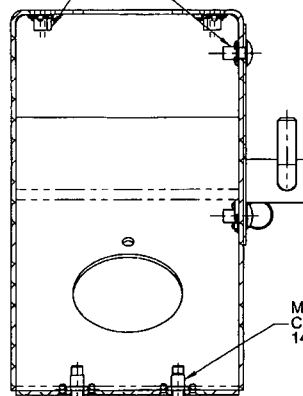
D3705-5
ACCESS PANEL

D3705-043 INSTRUMENT
PANEL WELDMENT

B2-1

D3707-3 MOUNTING LUG
2 PL

A B4-1

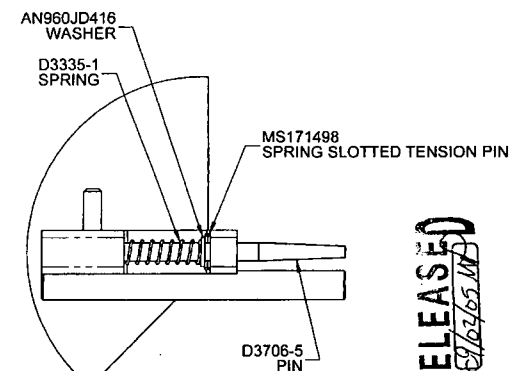


MS21075L3 NUTPLATE, 1X
CR1122-3-02.5 RIVET, 2X
14 PL

MS24693-C272 SCREW
4 PL

D3707-3 MOUNTING LUG
REF

SECTION A-A
SCALE 2X



DETAIL B
SCALE 2X

C	ADDED D3705-7/8-11 (SHEET 6); REMOVED MS35889-158 GROMMET; 9.31 AND 12.65 WERE 9.36 AND 12.61 (ZN B6-3); Ø 1.90 WAS 1.50 (ZN D5-4); ADDED Ø 0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS	MB	08.11.20
B	ADDED MS35489-158; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD10L (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3); REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT	MB	08.08.07
A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.20		

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HAWKESBURY, ONTARIO, CANADA

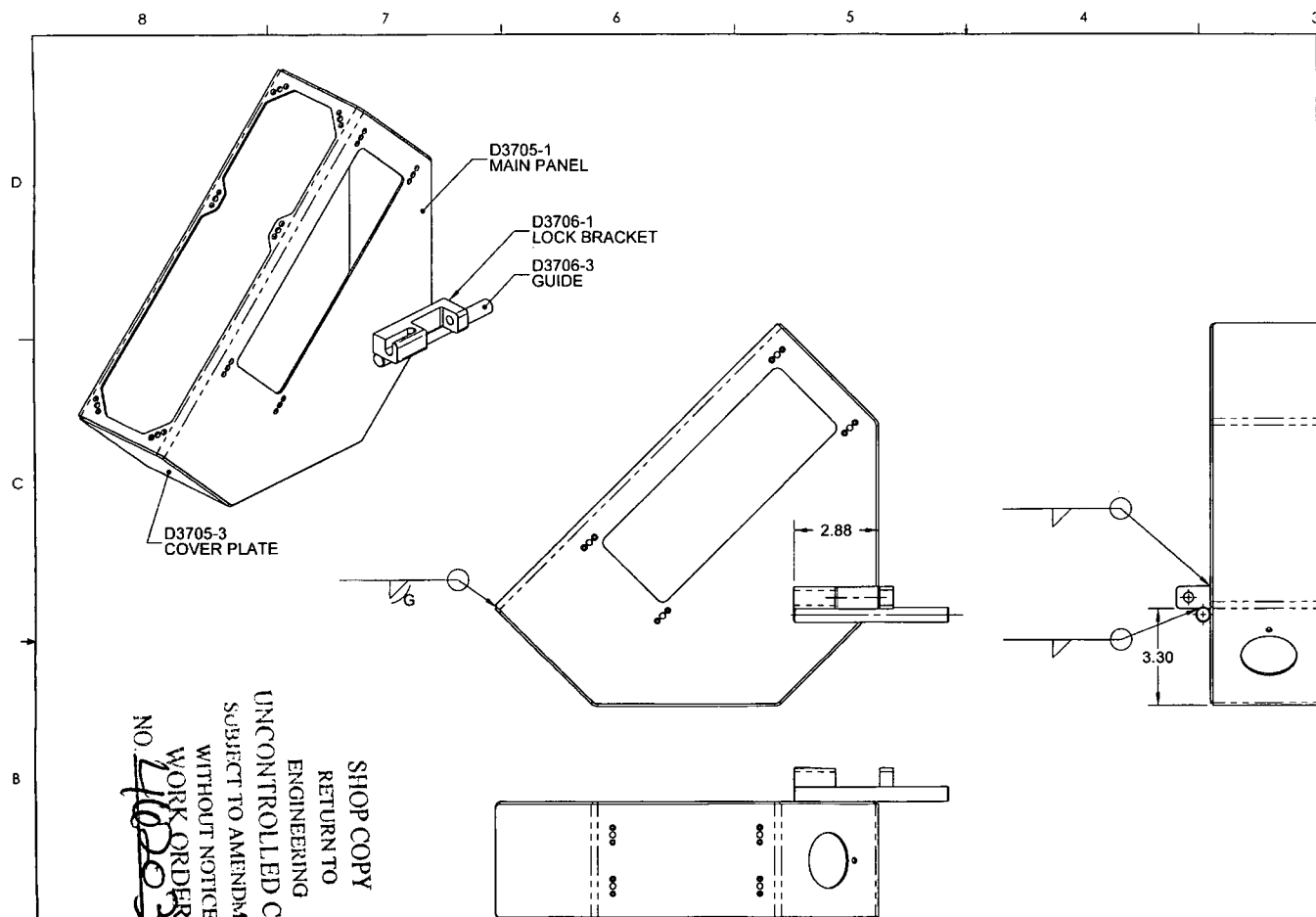
DRAWING NO. **D3705** REV. C
SHEET 1 OF 6
TITLE **INSTRUMENT PANEL ASS'Y** SCALE NTS

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NO. 400203

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

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WORK ORDER
NO. 410003

- D3705-043 NOTES:**
 1) MATERIAL: N/A
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 2.90 lbs
 8) WELDING: PER DART QSI 004

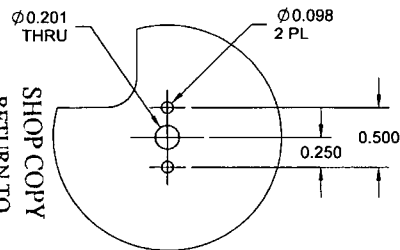
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WORK ORDER NO. 46003

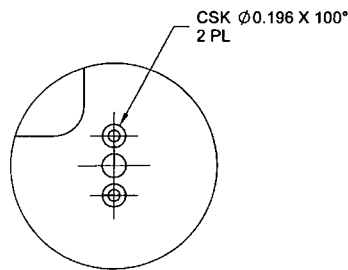
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DETAIL C
SCALE 4X
C4-3
10 PL

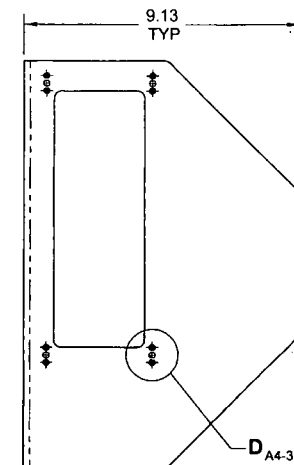
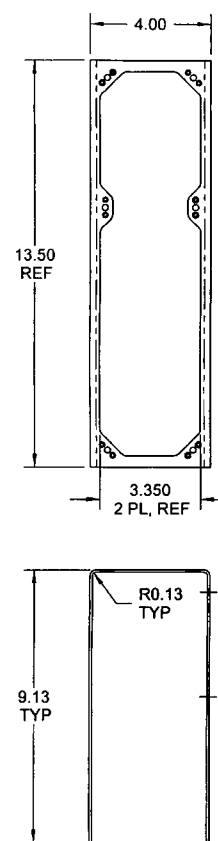


D3705-1F MAIN PANEL

DETAIL D
SCALE 4X
C1-3
10 PL



D3705-1 MAIN PANEL
MAKE FROM D3705-1F

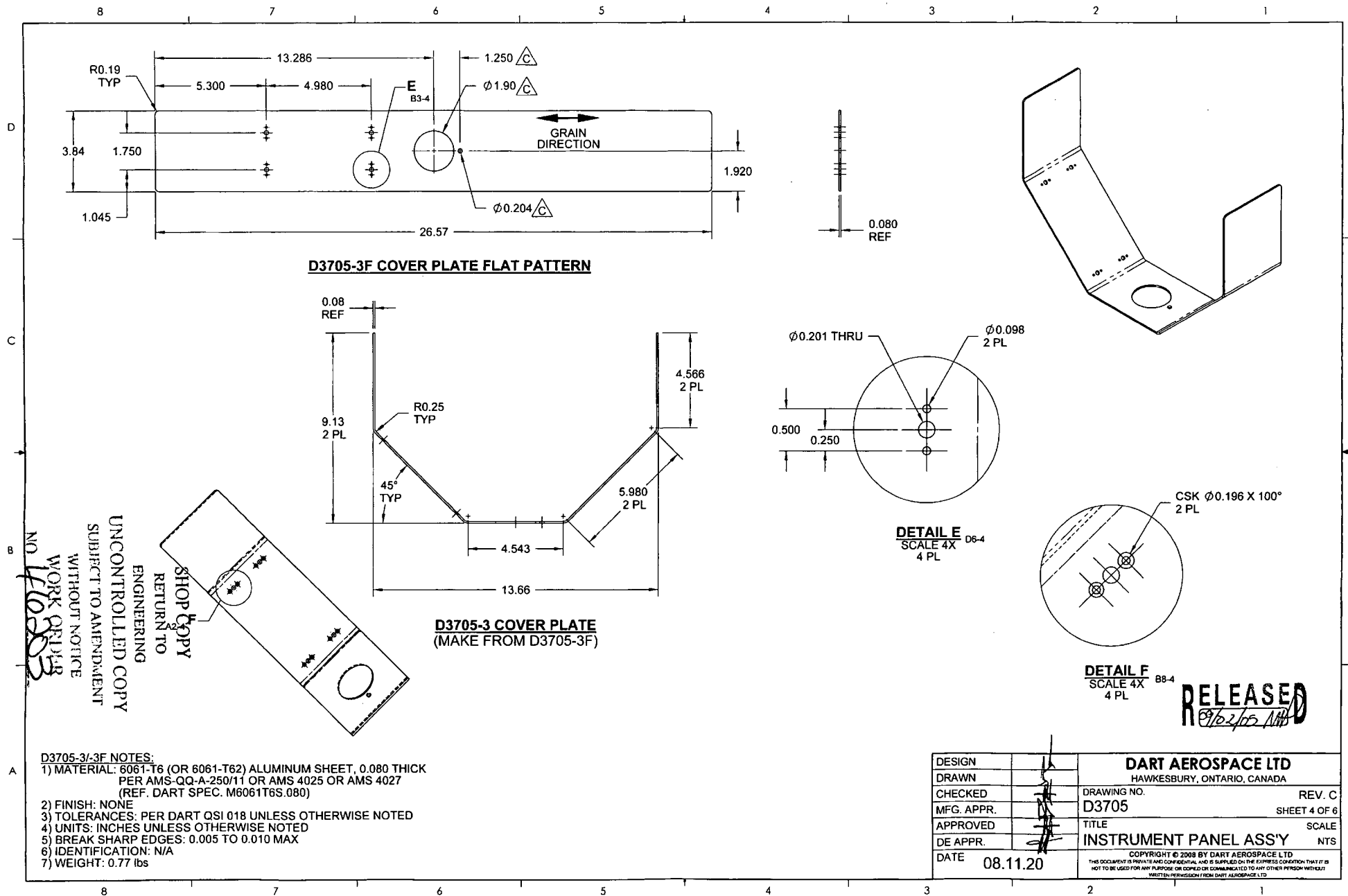


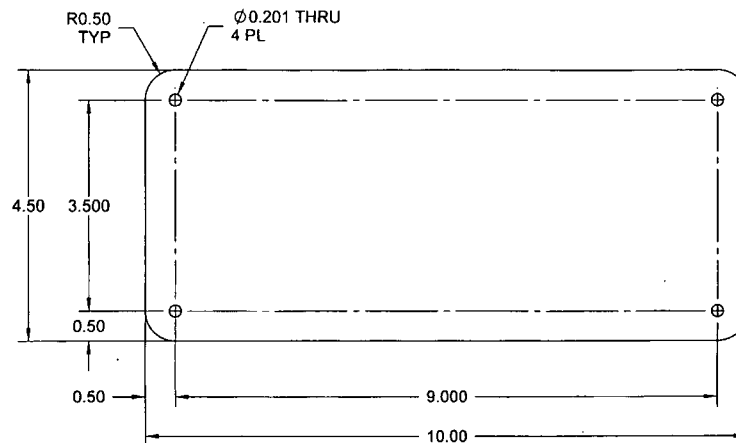
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D3705-1F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.49 lbs

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D3705-5 ACCESS PANEL

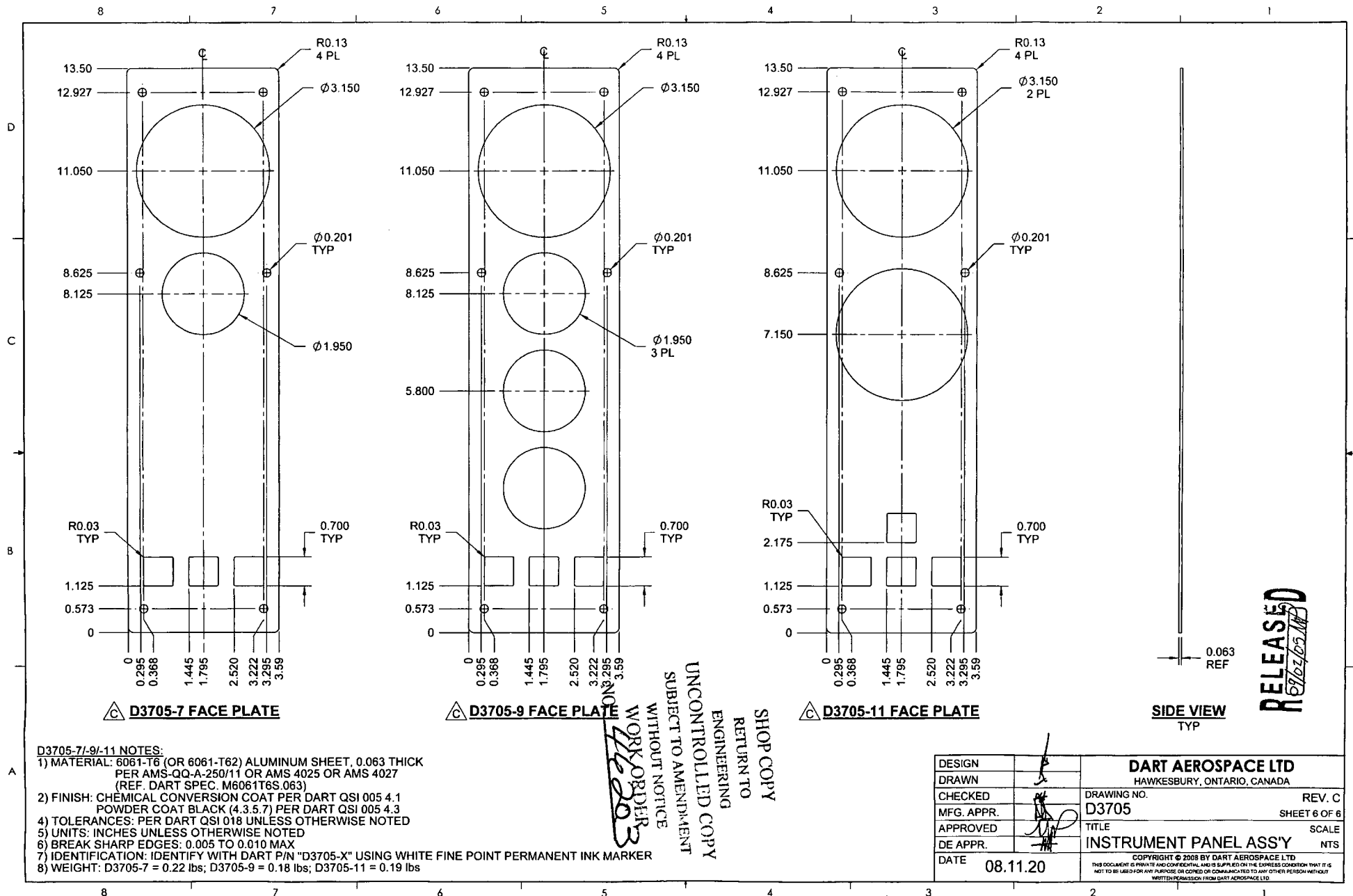
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D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

RELEASED
09/02/05 JWW

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